

Work Order ID 48248

Friday, June 26, 2009 9:04:00 AM



Page 1

Item ID: D3391-021

Accept



Setup Start



Revision ID: H

Stop



Item Name: Fwd Tube Assembly

Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CY MK Date: 09/09/24 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

D3391	Rev H
-------	-------

100		0.00
-----	--	------



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

Cut extrusion to 46.52 +0.010 -0.020

Q.A. 09-10-13

110		0.00
-----	--	------



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend as per Dwg D3391 Using Bend Prog 3391021

DP 9-10-14

120		0.00
-----	--	------



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

802/10/15

42

h2 7.060"
L° = 13.3°

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Page 3

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Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				1	8		
170 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				1	8		
180 Skidtubes Skidtubes	Skidtubes Memo 1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)□(ONLY DRILL HOLES MARKED "A")□2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step□3-Open tow cap hole	0.00 0.00							

MB
DP
9-10-22

Work Order ID 48248

Friday, June 26, 2009 9:04:00 AM

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Item ID: D3391-021

Accept

Setup Start

Revision ID: H

Stop

Item Name: Fwd Tube Assembly

Start Date: 7/15/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

190

QC5- Inspect part completeness to step on W/O

0.00

2) S 09/10/22



QC

Memo

0.00

Quality Control

(20)

/

200

Chemical Conversion Coat per QSI005 4.1

0.00

SAD



HandFinish

Memo

0.00

09-10-22

Hand Finishing

(1)

210

QC3- Inspect Part Finish

0.00



QC

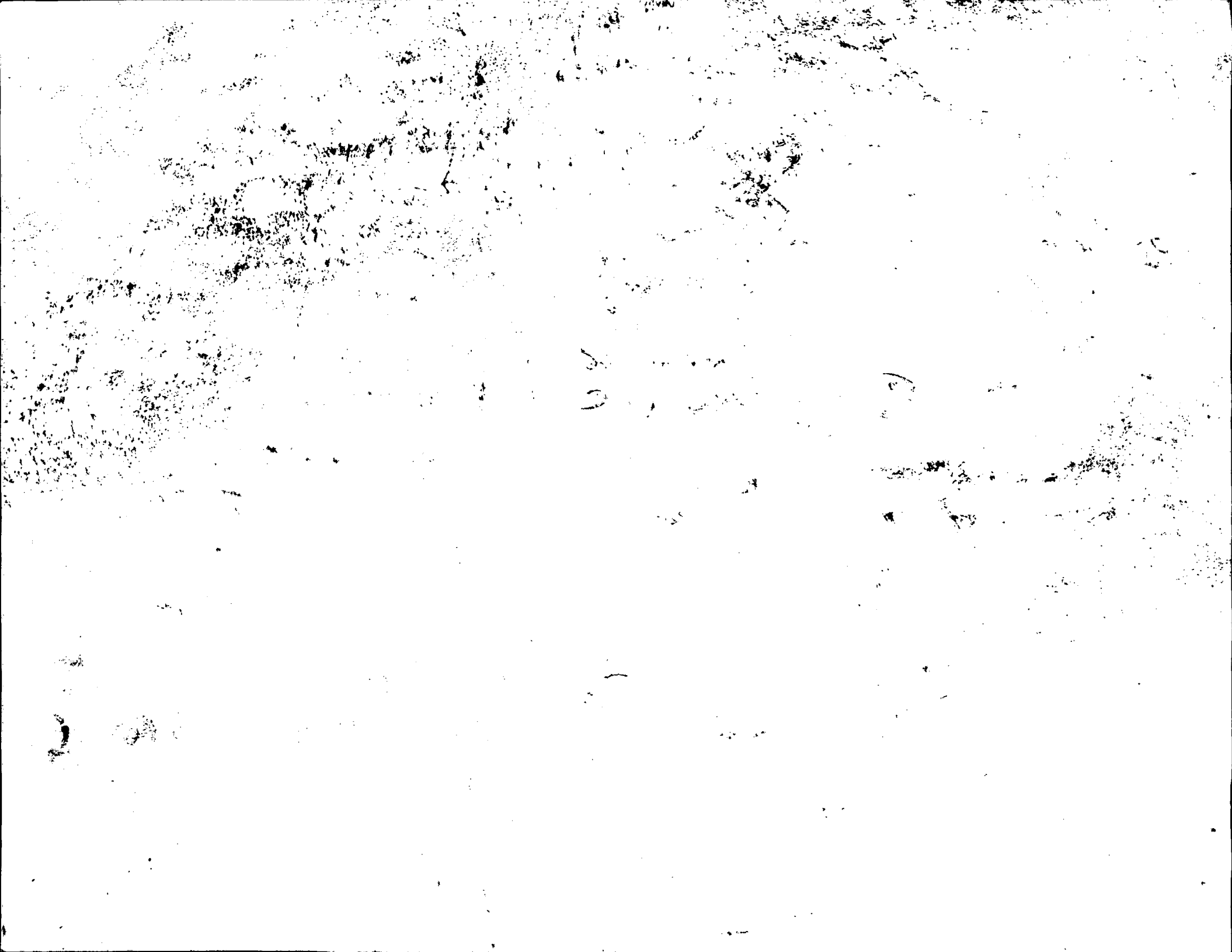
Memo

0.00

Quality Control

(1)





BE 09-10-28












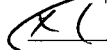

Work Order ID 48248

Friday, June 26, 2009 9:04:00 AM

Page 5

Item ID: D3391-021 Accept  Setup Start 
Revision ID: H Stop 
Item Name: Fwd Tube Assembly
Start Date: 7/15/2009 Start Qty: 1.00  Cust Item ID:
Required Date: 8/3/2009 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220  Skidtubes	Skidtubes	0.00							
	Memo 1-instal spacers as per dwg D3391 A/R Magnabond 6398 batch: <u>112417</u> exp. date: <u>11/1/20</u> cure time 12hrs. as per QSI015 2- grind crossbolt flush 3-back drill crossbolt if necessary	0.00						<u>MS/H 09-70-28</u>	
230  QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo 27 S on 10/10/09	0.00							
240  Powdercoat Powder Coating	* pressure-wash White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum <u>1112140</u>	0.00							
	Memo START TIME: <u>10:30A</u> COVEN TEMPERATURE: <u>11:00A</u> FINISH TIME: <u>3269</u>	0.00							

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Item ID:	D3391-021	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	Fwd Tube Assembly					
Start Date:	7/15/2009	Start Qty:	1.00	Cust Item ID:		
Required Date:	8/3/2009	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 	QC3- Inspect Part Finish	0.00	BR 09-10-29			①			
QC Quality Control	Memo	0.00							
270 	Identify as per dwg & Stock Location: _____	0.00	BR 09-10-3						
Packaging Packaging	Memo	0.00							
270 260 	Skidtubes	0.00							
Skidtubes Skidtubes	Memo	0.00							
	**** install D3591-1 spacer as per DS19364 ****		BR 09-10-29			①			
	install wear plate gasket as per dwg								
	Mo 09/10/09								
	⇒ QCS 8/2/03								

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Item ID: D3391-021

Accept



Setup Start



Revision ID: H

Stop



Item Name: Fwd Tube Assembly

Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev. Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

288 290



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/11/04

MF 09-11-04

Picklist Print

Friday, June 26, 2009 9:03:59 AM

Page 1

Work Order ID: 48248

Parent Item: D3391-021RevH

Parent Item Name: Fwd Tube Assembly

Comments:

Start Date: 7/15/2009

Required Date: 8/3/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AELS-1032-225		Purchased	No			100	Each	0.0000	10.0000			
INSERT												
✓ D6013-047RevA		Manufactured	No			220	Each	0.0000	1.0000			
Skidtube Material												
✓ AELS-1032-130		Purchased	No			260	Each	0.0000	2.0000			
INSERT												
✓ AN3C4A		Purchased	No			260	Each	0.0000	10.0000			
BOLT												
✓ AN960C10L		Purchased	No			260	Each	0.0000	10.0000			
washer												
✓ D3401-041RevB		Manufactured	No			260	Each	0.0000	1.0000			
Tow Cap Assembly												
✓ D3564-13RevD		Manufactured	No			260	Each	0.0000	1.0000			
Wearshoe												
✓ D3566-13RevC		Manufactured	No			260	Each	0.0000	1.0000			
Gasket												
✓ D3670-4-200RevA		Manufactured	No			260	Each	0.0000	4.0000			
SPACER												

13 47122

9/10/28

Picklist Print

Page 2

Friday, June 26, 2009 9:03:59 AM

Work Order ID: 48248



Parent Item: D3391-021RevH



Parent Item Name: Fwd Tube Assembly




Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3672-1RevB  Phenolic Washer		Manufactured	No			260	Each	0.0000	4.0000			
 <i>BH7628.</i>  <i>AD BR 09-10-29</i>												

Date: Thursday, 28/05/2009 9:12:17 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD TUBE ASSEMBLY
Job Number	: 48248		
Estimate Number	: 10467		
P.O. Number	:	Part Number	: D3391021
This Issue	: 28/05/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3391 REV H
First Issue	: / /	Project Number	: N/A
Previous Run	: 47307	Drawing Revision	: H
	Type : SKIDTUBES	Material	:
Written By	:	Due Date	: 12/06/2009
Checked & Approved By	: <u>28 09 05 28</u>	Qty:	1
Comment	Est. A 05.09.13 New issue KJ/JLM Est. B 06.02.10 Dwg rev.D ecn 773 EC Est. C 06.05.02 Added inspections EC est D 07.03.13 rev F dwg EC est E 07.11.07 revG dwg ecn1053P EC verified by: DD Est Rev:f ECN 1056 07-11-12 DD verified by: EC Est Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC Est Rev:H 08-09-10 revH as per dwg DD verified by:EC Est Rev J 09.02.02 added hardware EC verified by: DD Est Rev: K 09-05-05 Added QC5 at step 28 KJ Verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	✓	D6013047	Skidtube Material
-----	---	----------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

SKIDTUBE MAT'L

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D6013-047	Extrusion	
---	-----------	-----------	--

2.0	✓	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	---	-------------	-----------------------

**Comment:** LANDING GEAR RESOURCE 1

Cut extrusion to 46.52 +0.010 -0.020

3.0	✓	BENDING	BENDING MACHINE - SKIDTUBES
-----	---	---------	-----------------------------

**Comment:** Nc bender

Bend as per Dwg D3391 Using Bend Prog 3391021

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 28/05/2009 9:12:17 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 48248

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0

✓ HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA590 Rev. ____ & Dwg D3391 Rev. ____
Identify as D3391-1

2-Deburr

6.0

✓ QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

7.0

✓ MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill X1 Aft cap as per Dwg D3391 .1875" dia

8.0

✓ QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

9.0

✓ QC8

SECOND CHECK



Comment: SECOND CHECK

10.0

✓ SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 28/05/2009 9:12:18 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 48248

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6-Deburr & Scribe Batch number Inside aft end.

7-Transfer drill D3391-021 with D3391-023

11.0

✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

✓

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

13.0

✓

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0

✓

D36704200

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch: _____

15.0

✓

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-instal spacers as per dwg D3391

A/R Magnabond 6398 batch: _____

exp. date: _____

cure time 12hrs. as per QSI015

2- grind crossbolt flush

3-back drill crossbolt if necessary

16.0

✓

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 28/05/2009 9:12:18 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 48248

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0 ✓

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

18.0 ✓

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

19.0 ✓

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Cap Assembly

20.0 ✓

D356413

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

21.0 ✓

D356613

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

22.0 ✓

D36721

Phenolic Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Phenolic Washer

23.0 ✓

AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

BOLT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 28/05/2009 9:12:18 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 48248

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0



AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

washer

25.0



ALS41032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

26.0



ALS41032225

Insert



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

INSERT

27.0



SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: SKIDTUBESS RESOURCE 1

**** install D3591-1 spacer as per DSI9364 ****

28.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

29.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

30.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	48242
Description: Float Skidtube (412)		Part Number:	D3391-1
Inspection Dwg: D3391	Rev: 2 H PL	Page 1 of 1	

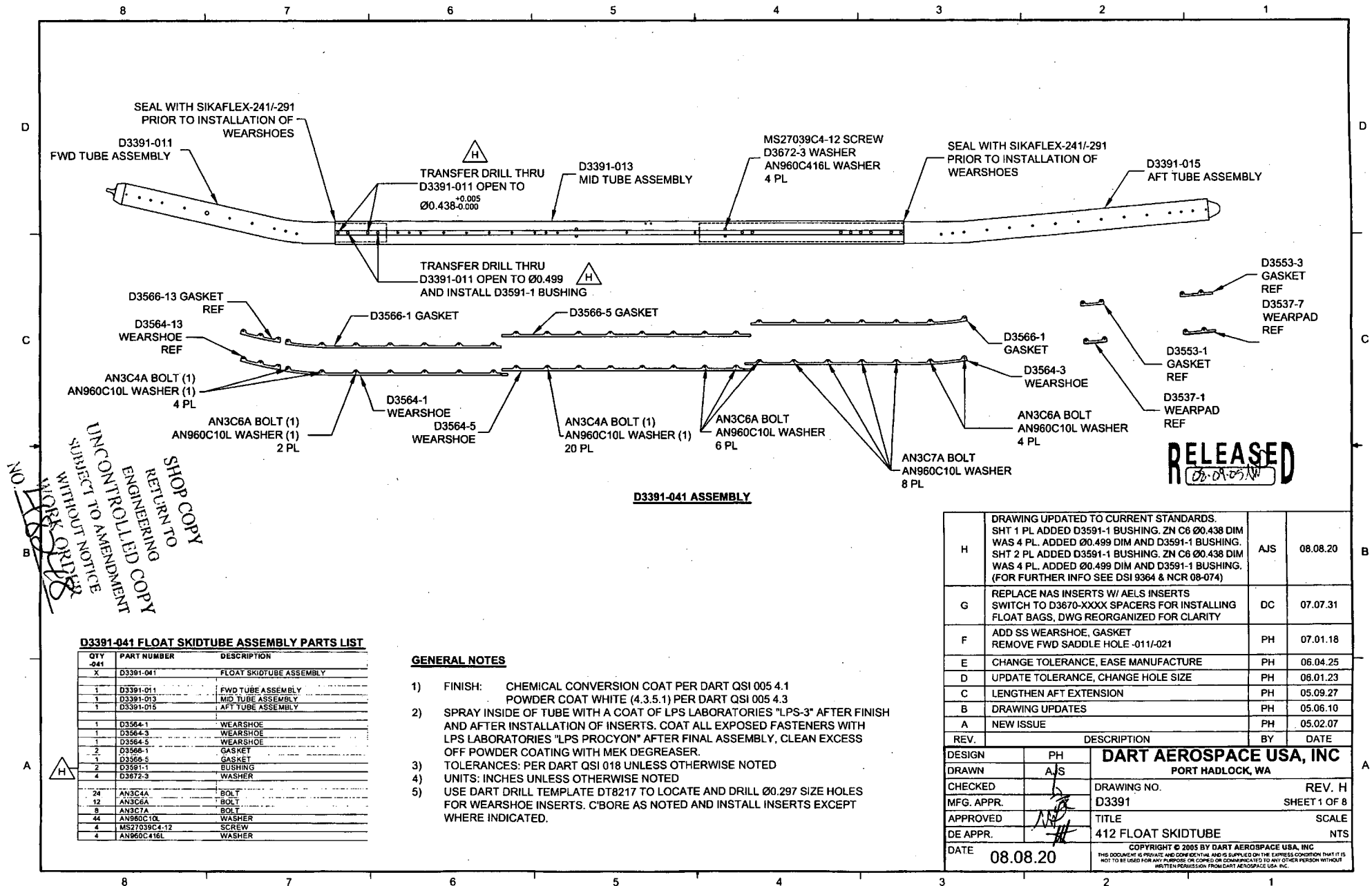
FIRST ARTICLE INSPECTION CHECKLIST

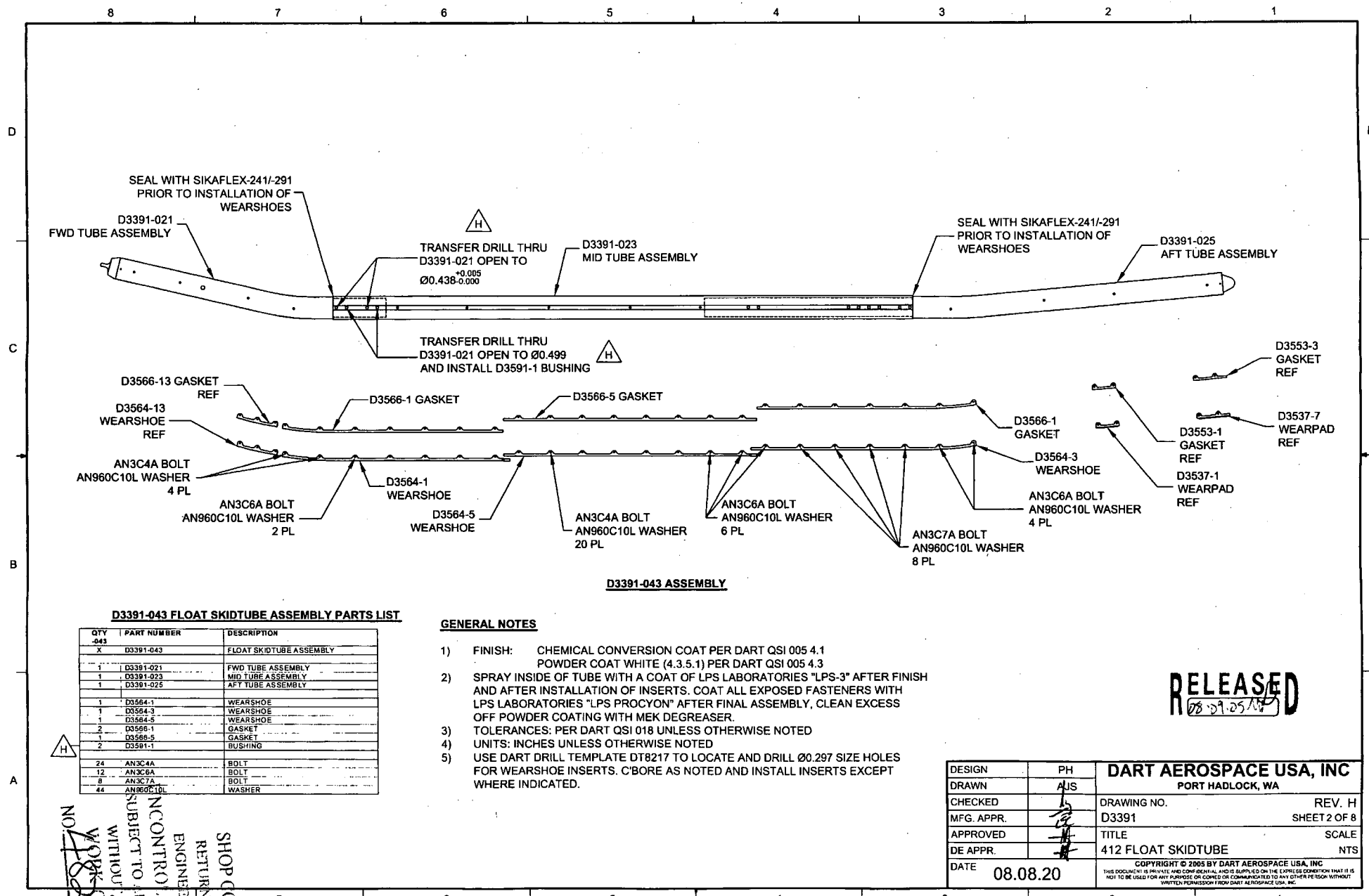
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+0.010/-0.000	0.690	✓			
3.590	+0.025/-0.010	3.602	✓			
3.300	+0.040/-0.000	3.327	✓			
1.429	+0.040/-0.060	1.464	✓			
4.250	+/-0.010	4.250	✓			
4.250	+/-0.010	4.250	✓			

Measured by: G.A	Audited by: [Signature]	Prototype Approval:	N/A
Date: 09/10/21	Date: 09/10/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.27	New Issue P/O D3391-011/-021	KJ/JLM	
B	06.06.19	Tolerances revised per D3391 Rev. E	KJ/JLM	
C	07.03.21	Dimensions removed per Dwg rev. F	KJ/JLM	
D	07.11.23	Dwg Rev. updated	KJ/EC/DD	[Signature]









D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3566-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

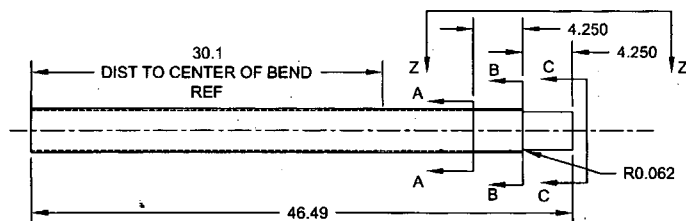
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C-BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

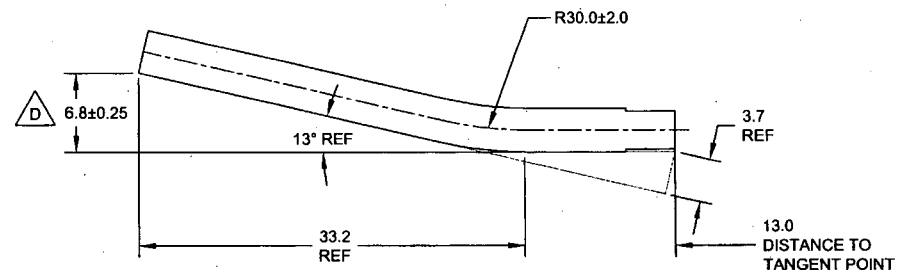
RELEASED
08-09-25-107

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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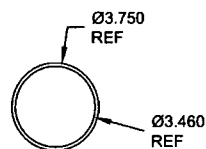
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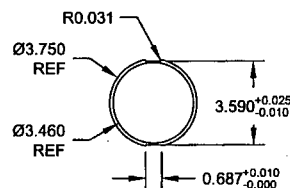
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



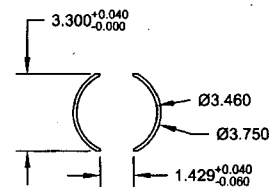
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



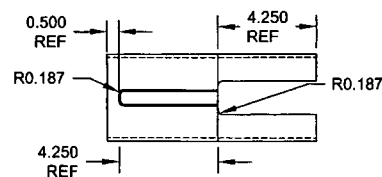
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

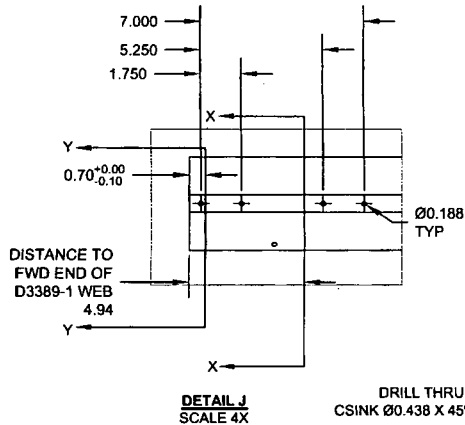


VIEW Z-Z
SCALE 2X

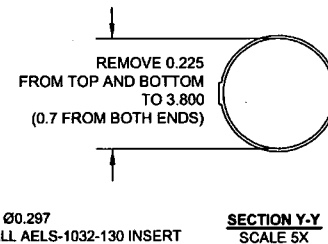
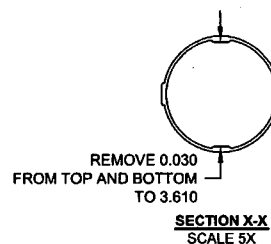
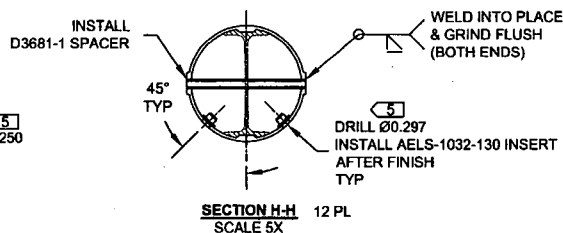
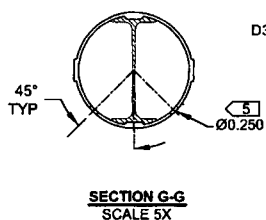
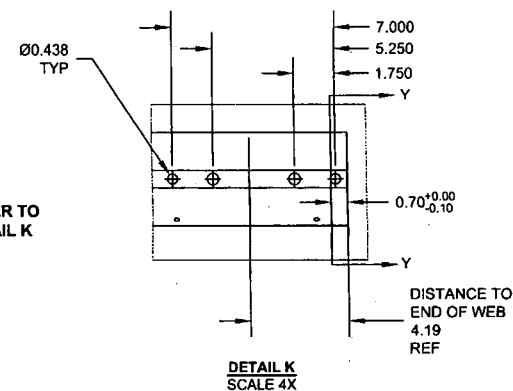
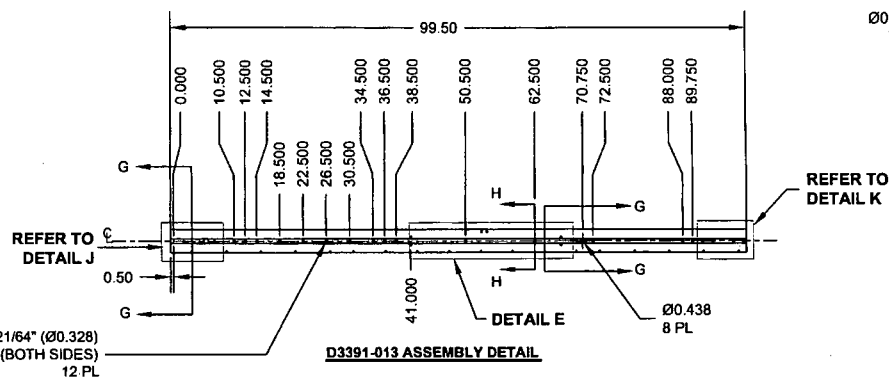
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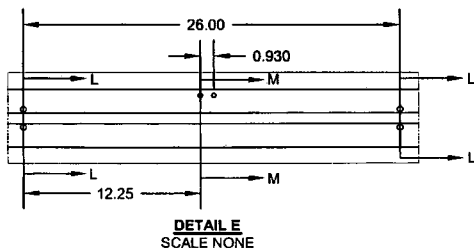


DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL

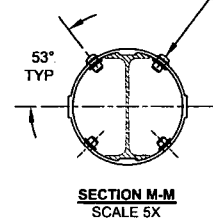
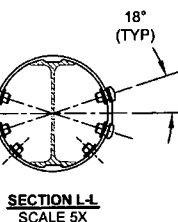


D3391-013 MID TUBE ASSEMBLY PARTS LIST

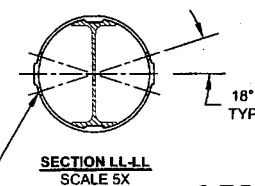
QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
4 PL



DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL

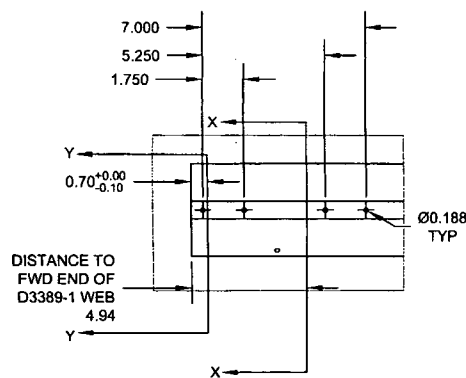


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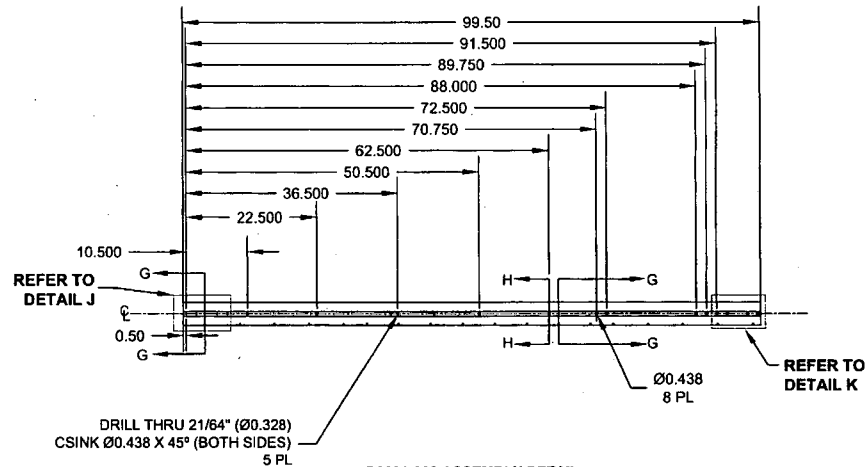
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MFG. APPR.		REV. H SHEETS OF 8
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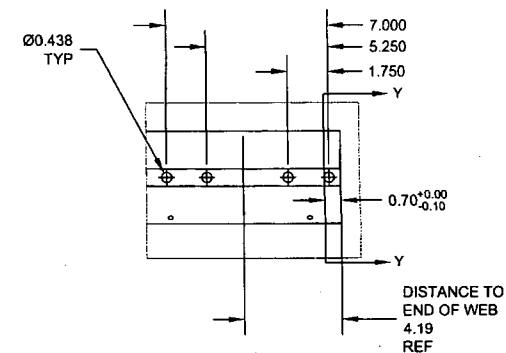
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DETAIL J
SCALE 4X



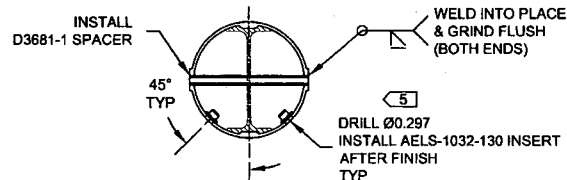
D3391-023 ASSEMBLY DETAIL



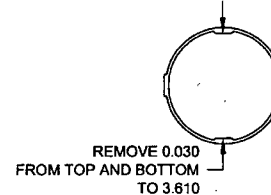
DETAIL K
SCALE 4X



SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X

REMOVE 0.225
FROM TOP AND BOTTOM
TO 3.800
(0.7 FROM BOTH ENDS)

SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

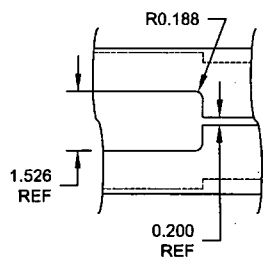
QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

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08-09-03-14

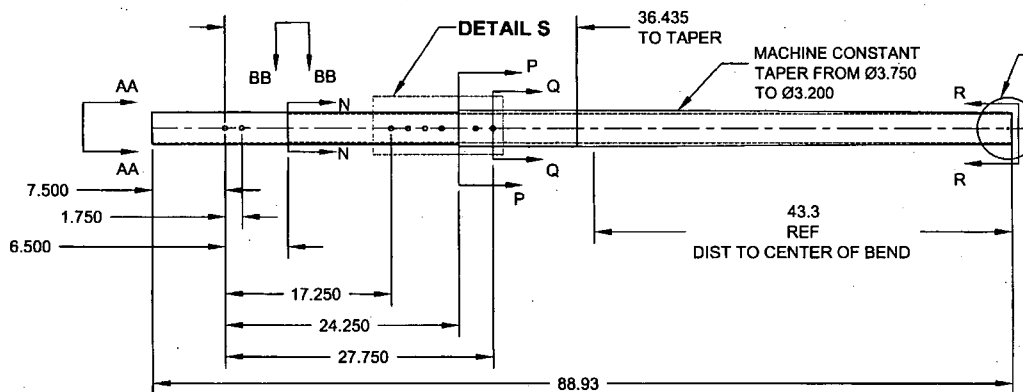
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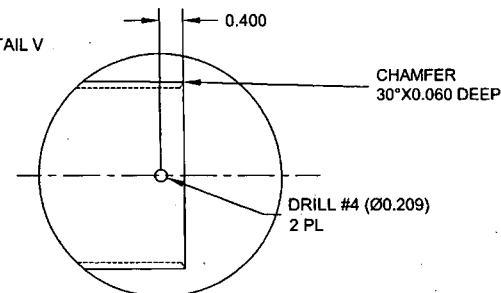
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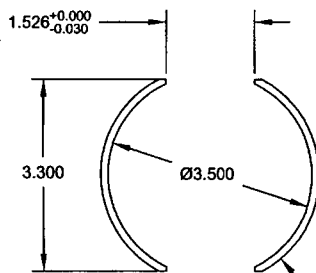
VIEW BB-BB
SCALE 4X



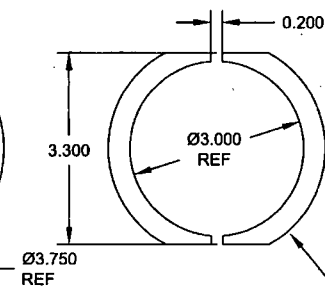
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



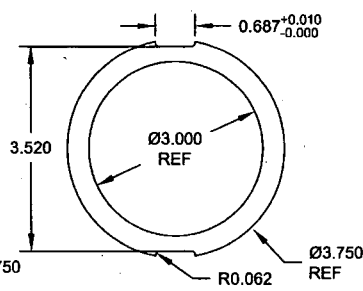
DETAIL V
SCALE 6X



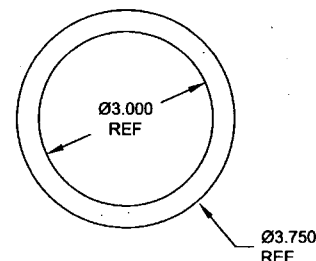
SECTION AA-AA
SCALE 6X



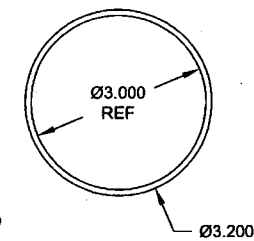
SECTION N-N
SCALE 6X



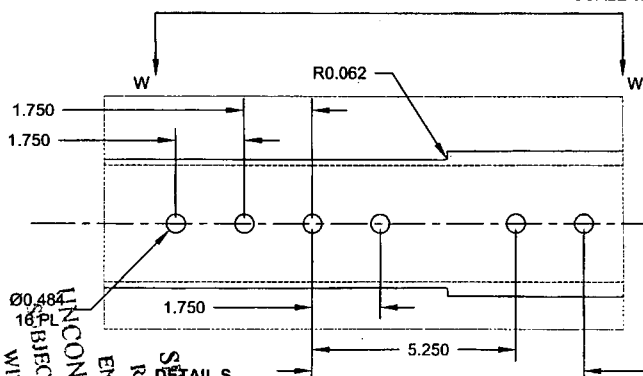
SECTION P-P
SCALE 6X



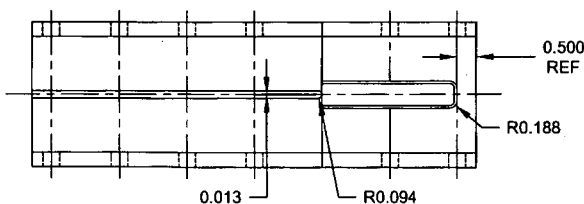
SECTION Q-Q
SCALE 6X



SECTION R-R
SCALE 6X



DETAIL S
SCALE 4X



VIEW W-W
SCALE 4X

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